



Dart Hawkesbury  
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Tel (613) 632-5200

**D206-667-147TRN**  
**Job Sheet 168214-C**



Part No: D206-667-147TRN

Job Qty: 1 ea

Part Name: Crosstube Assembly, Mid Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/30/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP rev:A 11.01.06 new issue DD verf:EC

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  | Workcenter/Supplier |                                 | Sign-off        |
|-------|--------------------|-------|------------|----------|-----------|---------------------|---------------------------------|-----------------|
|       |                    |       |            |          | Setup hrs | Run Hrs             | Workcenter / Supplier Lead Time |                 |
| 90    | Start up Operation | 1 Ea  |            | 11/29/17 | 0.00      | 0.00                | Start Up Crosstubes             | PMP             |
| 100   | Mori Seiki         | 1 pcs |            | 11/29/17 | 3.21      | 1.47                | Mori Seiki TL-40                | PMP             |
| 110   | QC                 | 1 pcs |            | 11/29/17 | 0.00      | 0.00                | QC2                             | PMP             |
| 120   | Mori Seiki         | 1 pcs |            | 11/29/17 | 0.00      | 1.47                | Mori Seiki TL-40                | PMP             |
| 130   | QC                 | 1 pcs |            | 11/29/17 | 0.00      | 0.00                | QC2                             | DAS PMP         |
| 140   | QC                 | 1 pcs |            | 11/29/17 | 0.00      | 0.00                | QC8                             | 47 17-12-28     |
| 145   | Crosstubes         | 1 pcs |            | 11/29/17 | 0.00      | 0.25                | Crosstube                       | 9-89 2018/01/04 |
| 150   | HandFXtube         | 1 pcs |            | 11/30/17 | 0.00      | 0.13                | Crosstube                       | GI              |
| 160   | QC                 | 1 pcs |            | 11/30/17 | 0.00      | 0.00                | QC7                             |                 |
| 170   | Packaging          | 1 pcs |            | 11/30/17 | 0.00      | 0.00                | Packaging3                      |                 |
| 180   | QC21-SA            | 1 Ea  |            | 11/30/17 | 0.00      | 0.00                | QC21                            |                 |

Part Op 100 - 1-Fill tube with sand & install plugs 206-147 on both ends as per Folio FB029 2-Turn first side as per Folio FB029  
Descriptions: 3-Blend transition lines only with belt sander 60 grit.

120 - 1-Turn second side as per Folio FB029 2-Blend transition lines only with belt sander 60 grit.

145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150 - 1- handfinish X-TUBE INSIDE AND OUT

170 - LOCATION : LG014

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated | Std Qty |
|-----------------------|----------------|----------|-----------|-----------|---------|
| 90-Start up Operation | D6002-115      | 1        | 88        | 0         | 0       |

B107867

### Part Specifications

Specifications could not be found.

Plex 11/13/17 12:43 PM dart.poulin.mario



**Dart Aerospace Ltd.**

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**Crosstube Assembly, Mid Fwd**

**PART NO: D206 – 667 – 147TRN**

**Revision:**

**Operation: Start up Operation**

**Change No:**

**Mfg Date: 11/23/17**

**Job No: 168214 – C**

|                                                 |                     |                     |
|-------------------------------------------------|---------------------|---------------------|
| <b>DART AEROSPACE LTD</b>                       | <b>Work Order:</b>  | <b>168214-C</b>     |
| <b>Description: Crosstube Assembly, Mid Fwd</b> | <b>Part Number:</b> | <b>D206-667-147</b> |
| <b>Inspection Dwg: D206-667-147 Rev: A</b>      |                     | <b>Page 1 of 2</b>  |

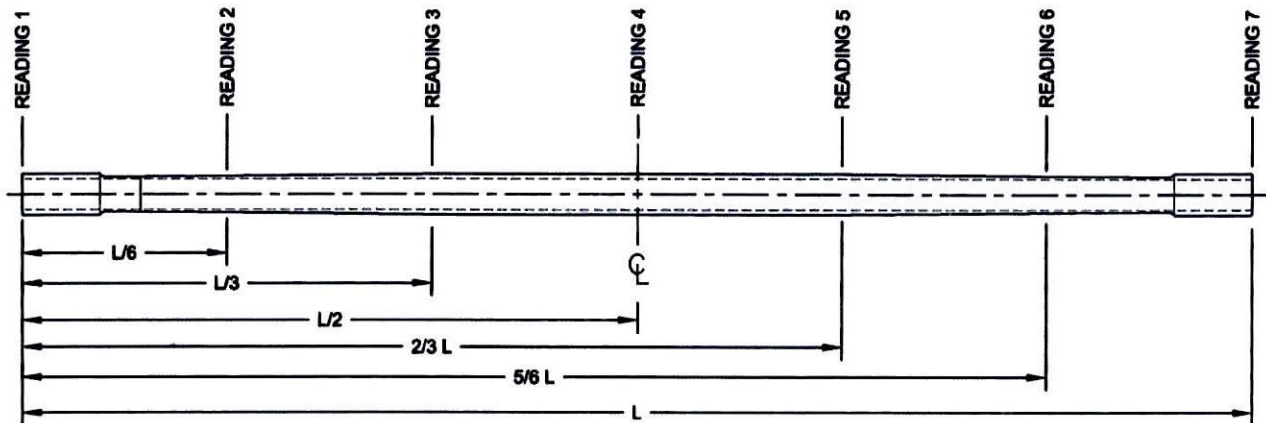
### FIRST ARTICLE INSPECTION CHECKLIST

|        | Inspection Sheet<br>Drawing Dimension | Tolerance     | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|--------|---------------------------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| SIDE A | 2.240                                 | +0.005/-0.000 | 2.2435              | ✓      |        | VERN 08                 |          |
|        | 1.984                                 | +0.005/-0.000 | 1.989               | ✓      |        |                         |          |
|        | 2.019                                 | +0.005/-0.000 | 2.024               | ✓      |        |                         |          |
|        | 2.058                                 | +0.005/-0.000 | 2.063               | ✓      |        |                         |          |
|        | 2.097                                 | +0.005/-0.000 | 2.102               | ✓      |        |                         |          |
|        | 2.136                                 | +0.005/-0.000 | 2.140               | ✓      |        |                         |          |
|        | 2.176                                 | +0.005/-0.000 | 2.1815              | ✓      |        |                         |          |
|        |                                       |               |                     |        |        |                         |          |
|        | 0.125                                 | +/-0.010      | .125                | ✓      |        | VERN 08                 |          |
|        | R0.063                                | +/-0.010      | .063                | ✓      |        | RG                      |          |
|        | R2.00                                 | +/-0.010      | 2.0                 | ✓      |        | RG                      |          |
|        | R0.063                                | +/-0.010      | .063                | ✓      |        | RG                      |          |
|        | 4.438                                 | +/-0.030      | 4.434               | ✓      |        | VERN 08                 |          |
|        |                                       |               |                     |        |        |                         |          |
|        |                                       |               |                     |        |        |                         |          |
| SIDE B | 2.240                                 | +0.005/-0.000 | 2.243               | ✓      |        | VERN 08                 |          |
|        | 1.984                                 | +0.005/-0.000 | 1.988               | ✓      |        |                         |          |
|        | 2.019                                 | +0.005/-0.000 | 2.023               | ✓      |        |                         |          |
|        | 2.058                                 | +0.005/-0.000 | 2.0625              | ✓      |        |                         |          |
|        | 2.097                                 | +0.005/-0.000 | 2.1015              | ✓      |        |                         |          |
|        | 2.136                                 | +0.005/-0.000 | 2.140               | ✓      |        |                         |          |
|        | 2.176                                 | +0.005/-0.000 | 2.180               | ✓      |        |                         |          |
|        |                                       |               |                     |        |        |                         |          |
|        | 0.125                                 | +/-0.010      | .125                | ✓      |        | VERN 08                 |          |
|        | R0.063                                | +/-0.010      | .063                | ✓      |        | RG                      |          |
|        | R2.00                                 | +/-0.010      | 2.0                 | ✓      |        | RG                      |          |
|        | R0.063                                | +/-0.010      | .063                | ✓      |        | RG                      |          |
|        | 4.438                                 | +/-0.030      | 4.433               | ✓      |        | VERN 08                 |          |
|        |                                       |               |                     |        |        |                         |          |
|        |                                       |               |                     |        |        |                         |          |
|        |                                       |               |                     |        |        |                         |          |
|        | 99.84                                 | +/-0.020      | 99.84               | ✓      |        | TAPE                    |          |



|                                                 |                     |                     |
|-------------------------------------------------|---------------------|---------------------|
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| <b>Inspection Dwg:</b> D206-667-147 Rev: A      |                     | <b>Page 2 of 2</b>  |

### WALL THICKNESS MEASUREMENT



| Location               | WALL THICKNESS MEASUREMENT (IN) |     |     |     | Deviation<br>$\Delta w$<br>(max-min) | TOLERANCE |
|------------------------|---------------------------------|-----|-----|-----|--------------------------------------|-----------|
|                        | w1                              | w2  | w3  | w4  |                                      |           |
| READING 1<br>L = 0"    | 243                             | 251 | 252 | 252 | .009                                 | 0.035"    |
| READING 2<br>L = 16.64 | 166                             | 164 | 164 | 172 | .008                                 |           |
| READING 3<br>L = 33.28 | 245                             | 245 | 252 | 250 | .007                                 |           |
| READING 4<br>L = 49.92 | 249                             | 253 | 255 | 257 | .008                                 |           |
| READING 5<br>L = 66.56 | 243                             | 248 | 250 | 250 | .007                                 |           |
| READING 6<br>L = 83.2  | 166                             | 173 | 165 | 165 | .008                                 |           |
| READING 7<br>L = 99.84 | 245                             | 250 | 254 | 251 | .009                                 |           |

#### Calibration Result

Actual Block Thickness: 100-300

Sitescan 250 Measured Thickness: 100-300

|              |                   |             |                          |                       |  |
|--------------|-------------------|-------------|--------------------------|-----------------------|--|
| Measured by: | <u>PMP</u>        | Audited by: | <u>47</u><br><u>9-89</u> | Preliminary Approval: |  |
| Date:        | <u>2017-11-21</u> | Date:       | <u>12-12-28</u>          | Date:                 |  |

| Rev | Date     | Change                    | Revised by | Approved |
|-----|----------|---------------------------|------------|----------|
| B   | 11.06.21 | New Issue                 | KJ         |          |
| C   | 12.06.04 | Wall thickness form added | KJ         |          |